

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029181**Date Inspected:** 27-Feb-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** USA Hoist**Location:** USA Hoist, Crest Hill, IL

CWI Name:	Robert Zimny		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No
Rod Oven in Use:	Yes	No N/A
Weld Procedures Followed:	Yes	No N/A
Verified Joint Fit-up:	Yes	No N/A
Approved WPS:	Yes	No N/A
Delayed / Cancelled:	Yes	No N/A

Bridge No: 34-0006**Component:** SAS Tower Elevator**Summary of Items Observed:**

Quality Assurance Inspector (QAI) Fritz Belford was at the USA Hoist shop in Crest Hill, Illinois between the times noted above in order to monitor Quality Control functions and the in process work being performed by USA Hoist personnel. The following items were observed:

Matt Wasigi (A):

Welder Wasigi was observed removing the temporary mounting bolts of the Door Mesh to the Door Frame and countersink drilling the door stop bolts holes for the door mesh M8 x 25MM LG, FHCS mounting bolts for doors 1, 2, 3, 4, 5 & 6.

Welder Wasigi was also observed welding tapped (threaded) spacers as nuts for the door mesh M8 x 25MM LG, FHCS mounting bolts at locations where the door mesh nuts and the door frame bolt holes do not align at door frame mesh 1, 2, 3, 4, 5 & 6. The welder was using 1.1mm E71T-1C Familiarc DW-50 wire electrode with a combination of 75% Argon and 25% CO2 with flow rate of 37 CFH. The welding parameters measured were 26 volts and 195 amperes and were in compliance with the Welding Procedure Specification (WPS) FCAW3210.

Jose Dominguez (C):

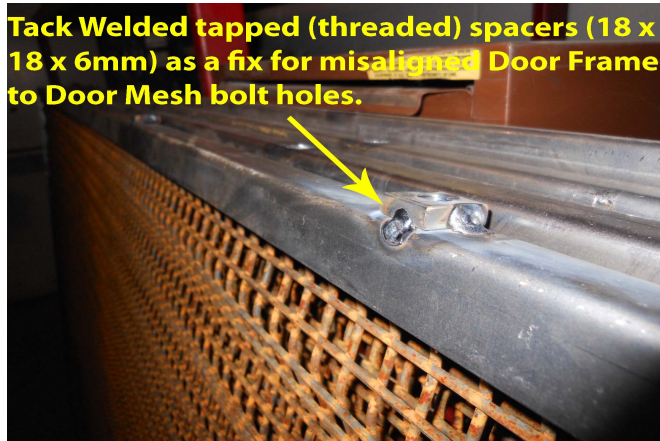
Welder Dominguez was observed continuing with machine cutting 6" x 6"x .375" tubular steel (Heat#0168580) for the elevator tower to the specified lengths. Cutting will continue on the following shift.

The completed and accepted work observed at this location appeared to be in compliance with the contract specifications.

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Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Tack Welded tapped (threaded) spacers (18 x 18 x 6mm) as a fix for misaligned Door Frame to Door Mesh bolt holes.



**Matt Wasigi (A):
Welder Wasigi countersink drilling the bolt holes for the door mesh 8MM 25MM LG FHCS mounting bolts.**



**Jose Dominguez (C):
Welder Dominguez measuring the 6" x 6" x .375" tubular steel (Heat#0168580) for the elevator tower before cutting.**

Summary of Conversations:

Conversations this day as required for scope of work.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Gary Thomas - (916) 764 - 6027, who represents the Office of Structural Materials for your project.

Inspected By: Belford,Fritz

Quality Assurance Inspector

Reviewed By: Foerder,Mike

QA Reviewer
